

## ABSTRACT OF THE DISCLOSURE

A numerical controller making it easy to prepare and alter sequence programs. Grouping is made according to signal type and/or signal address. Address tables AT1-1, AT2-2 are provided in which top physical addresses for respective group numbers are stored for every sequence program. The program includes object codes, each constituted by an instruction code, a group number, and an offset address. When the object code is read in, a top physical address for the instruction group number is read out from a table corresponding to the program. The offset address is added to the top physical address to determine a physical address of a signal and perform processing for the instruction code. Since the address tables are provided for every program to have different physical addresses, it is enough to prepare only one program for a common portion of a plurality of programs, and enough to alter only the address tables even if hardware is subject to alteration.